

AMENDMENTS TO THE CLAIMS

Claims 1-43 (Canceled).

44. (New) A method to produce an embossed web material, comprising at least two plies coupled to each other by gluing, including the following steps: producing on a first ply protuberances defining embossed decorative motifs; applying a glue to at least some of the protuberances defining the decorative motifs; making a second ply adhere to the first ply by means of said glue; wherein a colored pattern is applied to said first ply prior to producing said embossed decorative motifs by means of embossing.

45. (New) Method as claimed in claim 44, wherein said first ply is embossed between a pressure roller and an embossing roller provided with protuberances defining said decorative motifs, and wherein said glue is applied to said first ply while the first ply is still in contact with said embossing roller.

46. (New) Method as claimed in claim 44, including embossing the first ply a first time to produce thereon a first series of protuberances forming an embossed background pattern and subsequently embossing said first ply again to produce thereon a second series of protuberances of a

greater height and lesser density with respect to the protuberances of the first series and defining said decorative motifs.

47. (New) Method as claimed in claim 45, including embossing the first ply a first time to produce thereon a first series of protuberances forming an embossed background pattern and subsequently embossing said first ply again to produce thereon a second series of protuberances of a greater height and lesser density with respect to the protuberances of the first series and defining said decorative motifs.

48. (New) Method as claimed in claim 44, including the following steps:

- embossing the first ply to produce thereon a first series of protuberances forming an embossed background pattern;
- applying an ink to at least some of the protuberances of said first series to form said colored pattern;
- embossing said first ply again to produce thereon a second series of protuberances of a greater height and lesser density with respect to the protuberances of the first series and defining said decorative motifs, the protuberances of the first series and of the second series projecting from the same side of the ply;

- applying to the protuberances of the second series a glue;

- making a second ply adhere to the first ply by means of said glue.

49. (New) Method as claimed in claim 45, including the following steps:

- embossing the first ply to produce thereon a first series of protuberances forming an embossed background pattern;

- applying an ink to at least some of the protuberances of said first series to form said colored pattern;

- embossing said first ply again to produce thereon a second series of protuberances of a greater height and lesser density with respect to the protuberances of the first series and defining said decorative motifs, the protuberances of the first series and of the second series projecting from the same side of the ply;

- applying to the protuberances of the second series a glue;

- making a second ply adhere to the first ply by means of said glue.

50. (New) Method as claimed in claim 46, including the following steps:

- embossing the first ply to produce thereon a first series of protuberances forming an embossed background pattern;

- applying an ink to at least some of the protuberances of said first series to form said colored pattern;

- embossing said first ply again to produce thereon a second series of protuberances of a greater height and lesser density with respect to the protuberances of the first series and defining said decorative motifs, the protuberances of the first series and of the second series projecting from the same side of the ply;

- applying to the protuberances of the second series a glue;

- making a second ply adhere to the first ply by means of said glue.

51. (New) Method as claimed in claim 46, wherein the protuberances of the first series have an average density ranging from 20 to 100 protuberances/cm<sup>2</sup>.

52. (New) Method as claimed in claim 46, wherein the protuberances of the first series occupy a percentage lower than 25% of the total surface of the first ply.

53. (New) Method as claimed in claim 44, wherein said glue is colored.

54. (New) Method as claimed in claim 53, wherein said glue and said ink have different shades of a same color.

55. (New) Method as claimed in claim 44, wherein said second ply is embossed with background embossing prior to coupling with the first ply.

56. (New) Method as claimed in claim 55, wherein said second ply is embossed with a third series of protuberances with an average density ranging from 20 to 100 protuberances/cm<sup>2</sup>.

57. (New) Method as claimed in claim 55, wherein the protuberances of said third series occupy a percentage below 25% of the total surface of the second ply.

58. (New) Method as claimed in claim 44, wherein the decorative motifs formed by the protuberances of the second series are distributed according to a density not exceeding 3 motifs/cm<sup>2</sup>.

59. (New) Method as claimed in claim 44, wherein said colored pattern is produced by printing the first smooth ply.

60. (New) Method as claimed in claim 59, wherein first ply is micro-embossed after said colored pattern is applied.

61. (New) Method as claimed in claim 44, wherein said printed pattern is a background pattern distributed essentially uniformly over the entire surface of the ply.

62. (New) Method as claimed in claim 44, wherein said first ply is provided with a colored background pattern constituted by stippling or by a series of lines.

63. (New) Method as claimed in at least claim 48, wherein said protuberances of the first series are colored to form a colored background pattern.

64. (New) Method as claimed in claim 44, wherein said colored pattern is phased with said decorative patterns to form a composite printed and embossed pattern.

65. (New) A device to produce an embossed web material, including: an embossing unit with an embossing roller equipped with a series of protuberances defining decorative motifs; a glue dispenser, arranged adjacent said embossing roller and co-acting therewith to apply glue to a first ply embossed by said embossing unit when said first ply is still in contact with said embossing roller; a laminating member disposed around a periphery of the embossing roller, downstream of the glue dispenser with respect to a direction of feed of said first ply to apply by lamination a second ply to the first ply; wherein, disposed upstream of said embossing unit, along a path of the first

web material, are means to apply a colored pattern to said first ply, prior to embossing by means of said embossing roller.

66. (New) Device as claimed in claim 65, wherein said means to apply a colored pattern on the first ply comprise at least a printing unit.

67. (New) Device as claimed in claim 65, including in combination: a first embossing unit with a first embossing roller equipped with a first series of protuberances; downstream of said first embossing unit, a second embossing unit with a second embossing roller equipped with a second series of protuberances of greater height and lesser density with respect to the protuberances of said first series, said protuberances defining decorative motifs, said glue dispenser being arranged around said second embossing roller, to apply a glue at the protuberances of said second embossing roller; said laminating member being associated with said second embossing roller.

68. (New) Device as claimed in claim 66, including in combination: a first embossing unit with a first embossing roller equipped with a first series of protuberances; downstream of said first embossing unit, a second embossing unit with a second embossing roller equipped with a second series of protuberances of greater height and lesser density

with respect to the protuberances of said first series, said protuberances defining decorative motifs, said glue dispenser being arranged around said second embossing roller, to apply a glue at the protuberances of said second embossing roller; said laminating member being associated with said second embossing roller.

69. (New) Device as claimed in claims 68, wherein said at least one printing unit is arranged around said first embossing roller and applies an ink to said first ply to at least some of the protuberances of the first embossing roller.

70. (New) Device as claimed in claim 67, wherein the protuberances of the first embossing roller have an average density ranging from 20 to 100 protuberances/cm<sup>2</sup>.

71. (New) Device as claimed in claim 65, wherein said glue dispenser contains a colored glue.

72. (New) Device as claimed in claim 65, wherein the decorative patterns defined by the protuberances of the second series have a density not exceeding 3 motifs/cm<sup>2</sup>.

73. (New) Device as claimed in claim 66, including in combination: a first embossing unit with a first embossing roller equipped with a first series of protuberances; downstream of said first embossing unit, a second embossing unit with a second embossing roller equipped with a second



series of protuberances of greater height and lesser density with respect to the protuberances of said first series, said protuberances defining decorative motifs, said glue dispenser being associated with said second embossing roller, to apply a glue at the protuberances of said second embossing roller; said laminating member being associated with said second embossing roller; and wherein said at least a printing unit, which applies an ink to said first ply, is disposed upstream of said second embossing unit and, optionally, upstream of said first embossing roller.

74. (New) Device as claimed in claim 66, wherein said printing unit and said embossing roller equipped with protuberances defining said decorative patterns are phased with each other to produce composite printed and embossed patterns.

75. (New) A sheet material comprising at least a first ply and a second ply glued together, wherein said first ply is equipped with at least a decorative embossing formed by a series of protuberances; said first ply and said second ply being glued together by means of a glue applied to at least some of said protuberances; and wherein said first ply is equipped with a colored pattern.

76. (New) Material as claimed in claim 75, wherein said first ply is equipped with background embossing formed

by a first series of protuberances and decorative embossing formed by a second series of protuberances of lesser density with respect to the protuberances of the first series; said first ply and said second ply being glued together by a glue applied to at least some of said protuberances of the second series, the protuberances of the first series being essentially free of glue.

77. (New) Material as claimed in claim 76, wherein at least some of the protuberances of the first series are colored.

78. (New) Material as claimed in claim 75, wherein said glue is colored.

79. (New) Material as claimed in claims 78, wherein said glue is colored and wherein said protuberances of the first series are colored with a different shade of the same color with which the glue is colored.

80. (New) Material as claimed in claim 76, wherein the protuberances of the first series have an average density ranging from 20 to 100 protuberances/cm<sup>2</sup>.

81. (New) Material as claimed in claim 75 wherein the colored surface of said first ply is lower than 25% of the total surface of the first ply.

82. (New) Material as claimed in claim 76, wherein the protuberances of the second series define decorative

motifs distributed according to a density not exceeding three motifs/cm<sup>2</sup>.

83. (New) Material as claimed in claim 75, wherein said second ply has a background embossing defined by a third series of protuberances.

84. (New) Material as claimed in claim 83, wherein the protuberances of said third series are distributed with a density ranging from 20 to 100 protuberances/cm<sup>2</sup>.

85. (New) Material as claimed in claim 75, wherein said second ply is free of protuberances added to the second ply after its production.

86. (New) Material as claimed in claim 75, wherein the base color of said first ply and second ply is neutral.

87. (New) Material as claimed in claim 76, wherein said colored pattern is a background pattern constituted by coloring the protuberances of said first series of protuberances forming the background embossing.

88. (New) Material as claimed in claim 75, wherein said colored pattern and said decorative embossing are phased with each other to form composite printed and embossed decorations.

89. (New) Material as claimed in claim 88, wherein said printed colored pattern is a background pattern

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distributed essentially uniformly over the entire surface of the ply.

90. (New) Material according to claim 89, wherein said printed background pattern is constituted by a stippling or by a series of lines.